

Date: Wednesday, 3/7/2007 4:26:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACEPOD BODY LH		
Job Number	: 31078B			Part Number	: D31881M		
Estimate Number	: 12595			Drawing Number	: D3188		
P.O. Number	:			Project Number	: N/A		
This Issue	3/7/2007	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	3/7/2007	Type	SMALL /MED FAB	Due Date	3/30/2007	Qty:	1
Previous Run	31047B				Um:	Each	
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B revc dwg 07.01.11 ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D2213	Aluminum Spacer	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Ship To Delastek			
8 D2213 Spacer Batch:			
2.0	PG	PURCHASING	
Comment: PURCHASING Issue P/O: _____ Description: D3188-1M BODY Ship: D2213 Spacers Supplier: Delastek Conformity Certificate and Process sheet required Ship 2 Items from Previous steps			
3.0	D31881P	Spacepod Body	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spacepod Body			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3//2007 4:26:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 31078B

Part Number: D31881M

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188. Visual inspection. Check for void spot and pins.

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**07.02.27 *#***GENERAL NOTES:**

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
 12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
 18 oz ROVING "E" GLASS (18 oz CLOTH)
 OWENS CORNING MILLED FIBERS, "E" GLASS
 3MK20 GLASS BUBBLES

FOAM: A500 CORE CELL
 OR DIVINYCELL
 OR AIREX
 OR KLEGECELL
 FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-8	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
 NO. 31078B

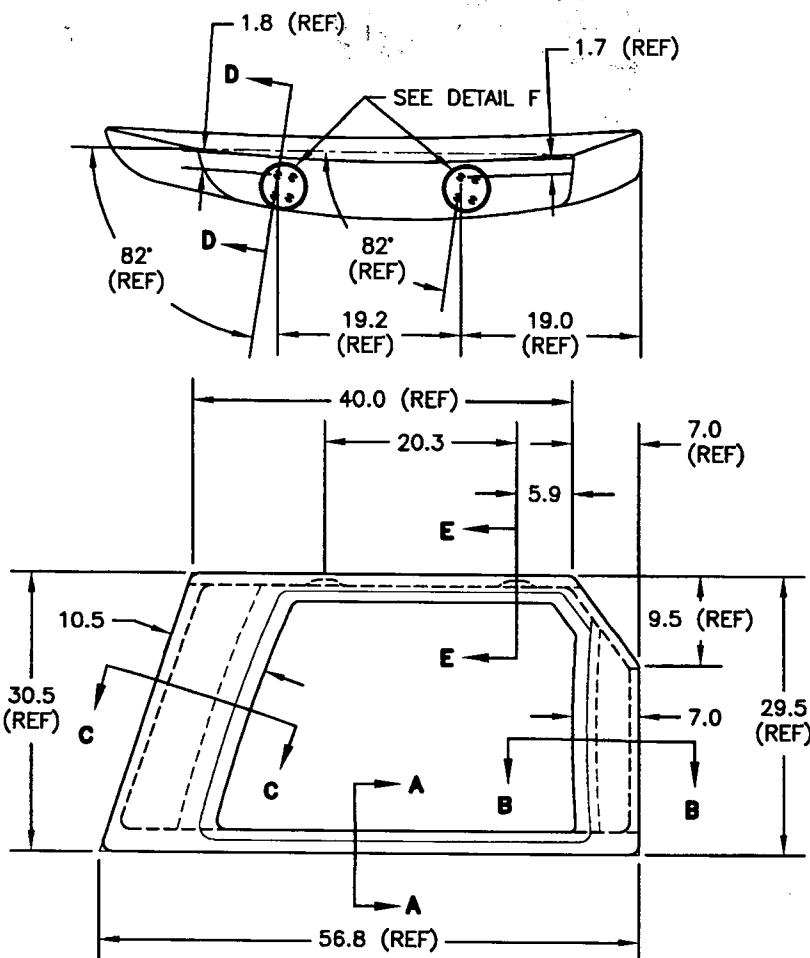
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CHECKED <i>JB</i>	APPROVED <i>#</i>	DRAWING NO. D3188	REV. D SHEET 1 OF 11
DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

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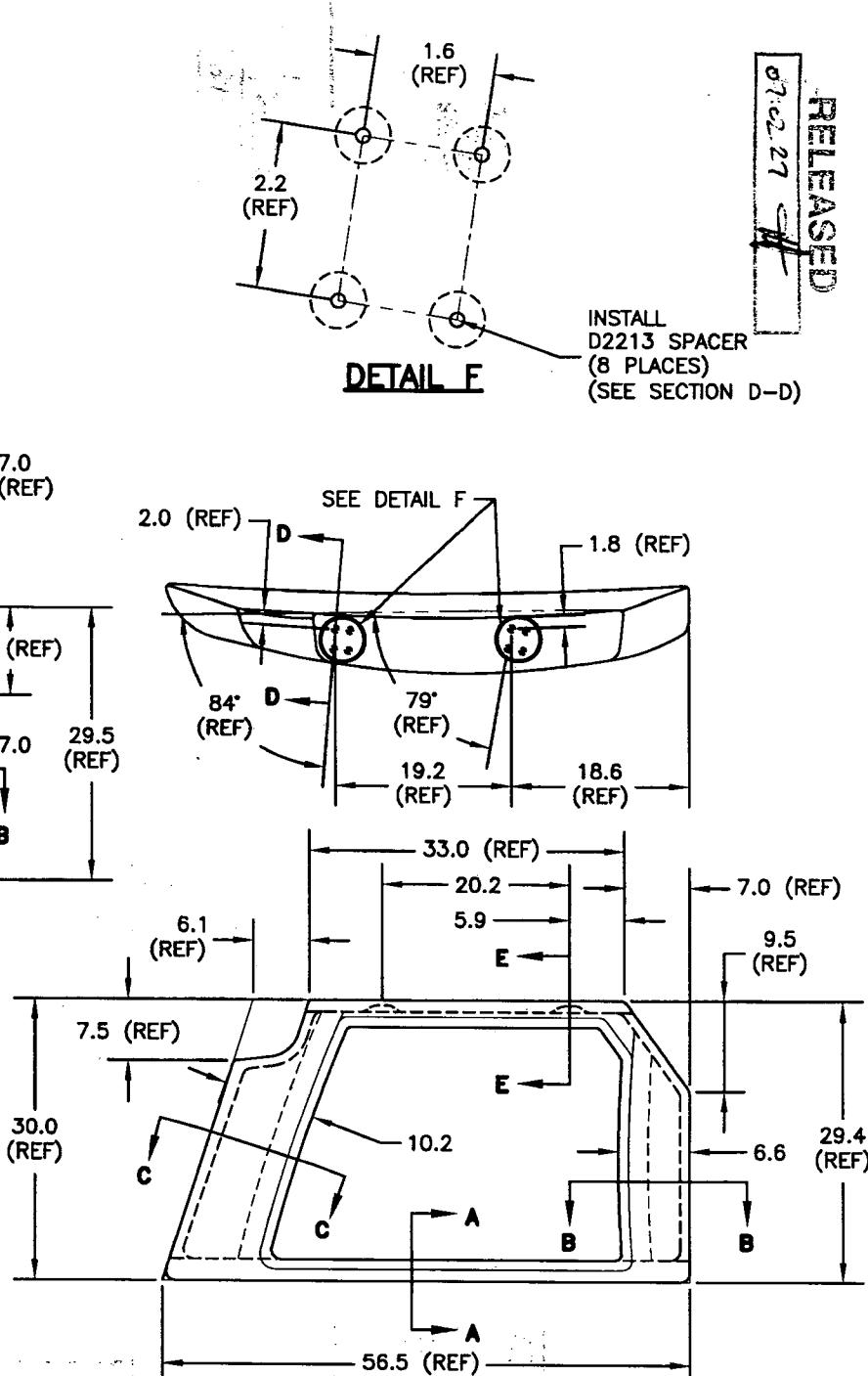


D3188-1M SPACEPOD BODY

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D3186-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.



D3188-3M SPACEPOD BODY

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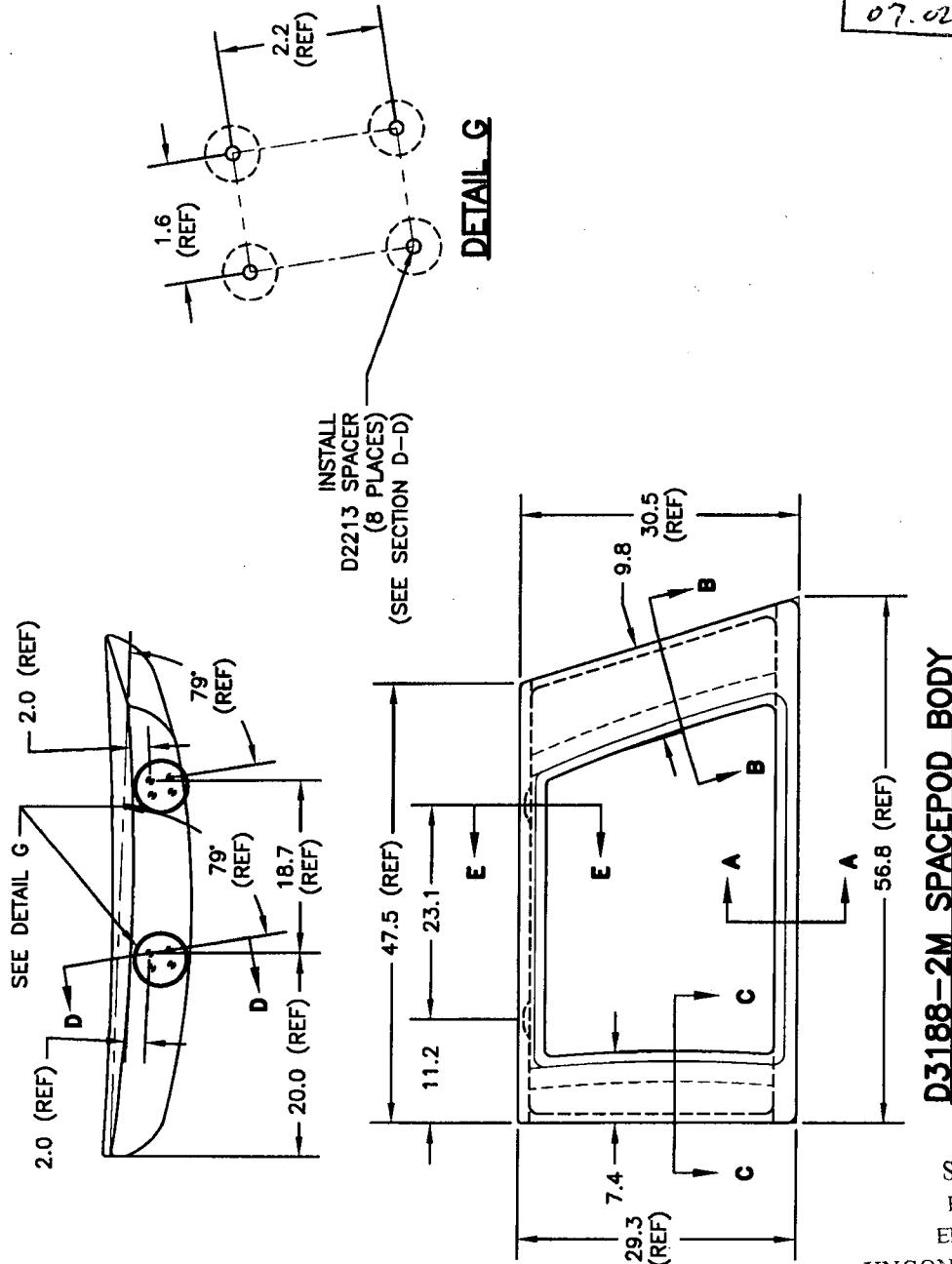
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<i>JB</i>	<i>W</i>
DATE	TITLE
07.02.22	SPACEPOD BODY
SHEET 2 OF 111	
REV. D	
SCALE	
NTS	

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DATE 07.02.22		REV. D SHEET 3 OF 11 TITLE SPACEPOD BODY SCALE NTS

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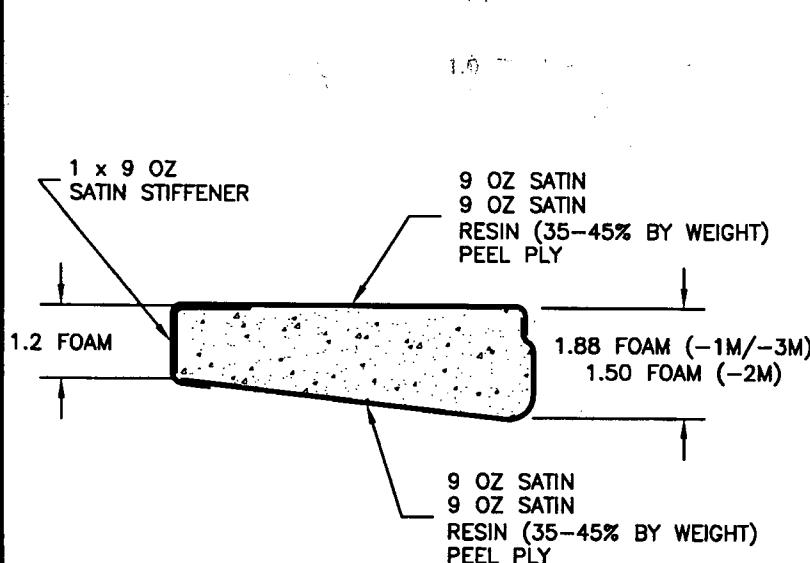
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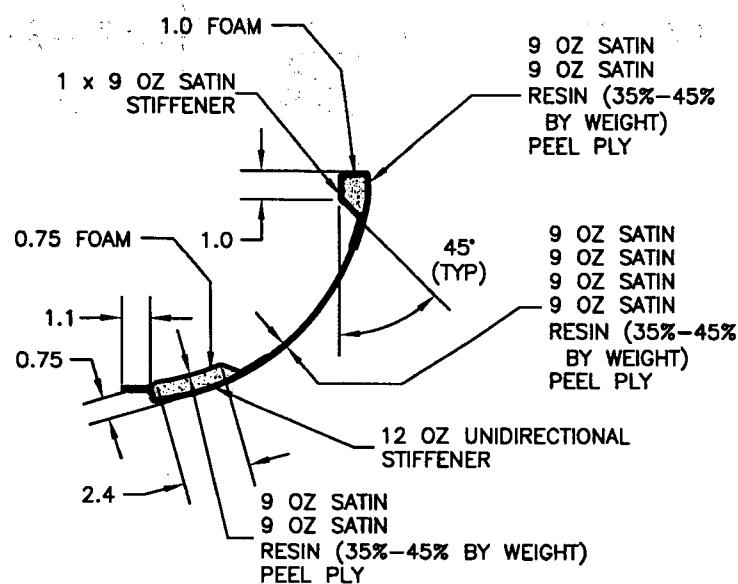
D3188-2M NOTES:
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

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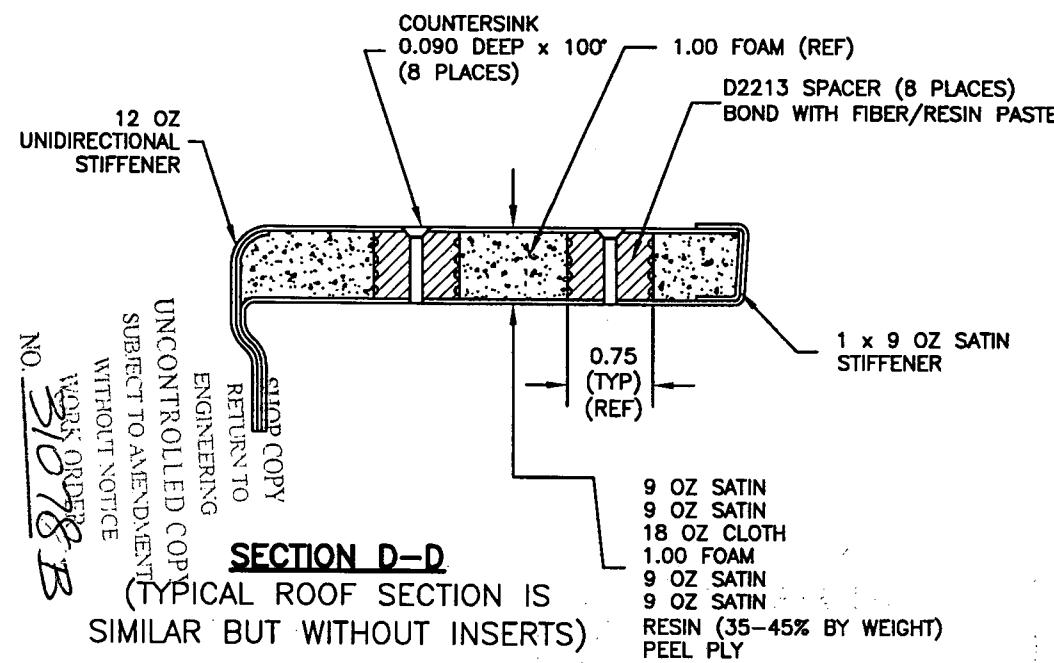
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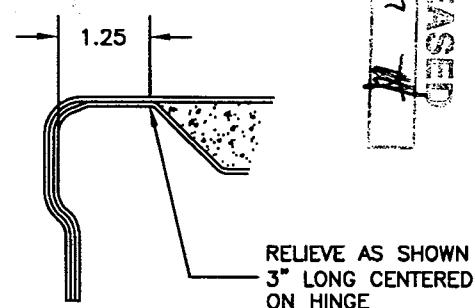
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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DATE 07.02.22		TITLE SPACEPOD BODY	REV. D SHEET 4 OF 11 SCALE NTS

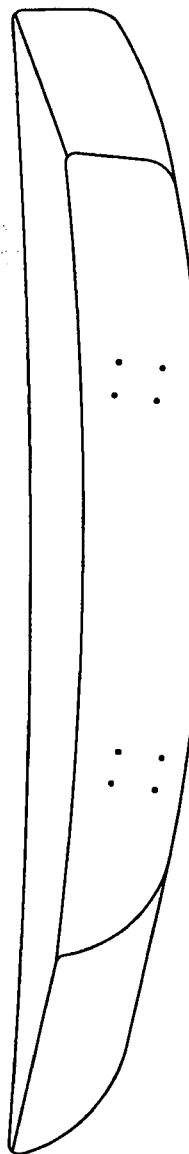
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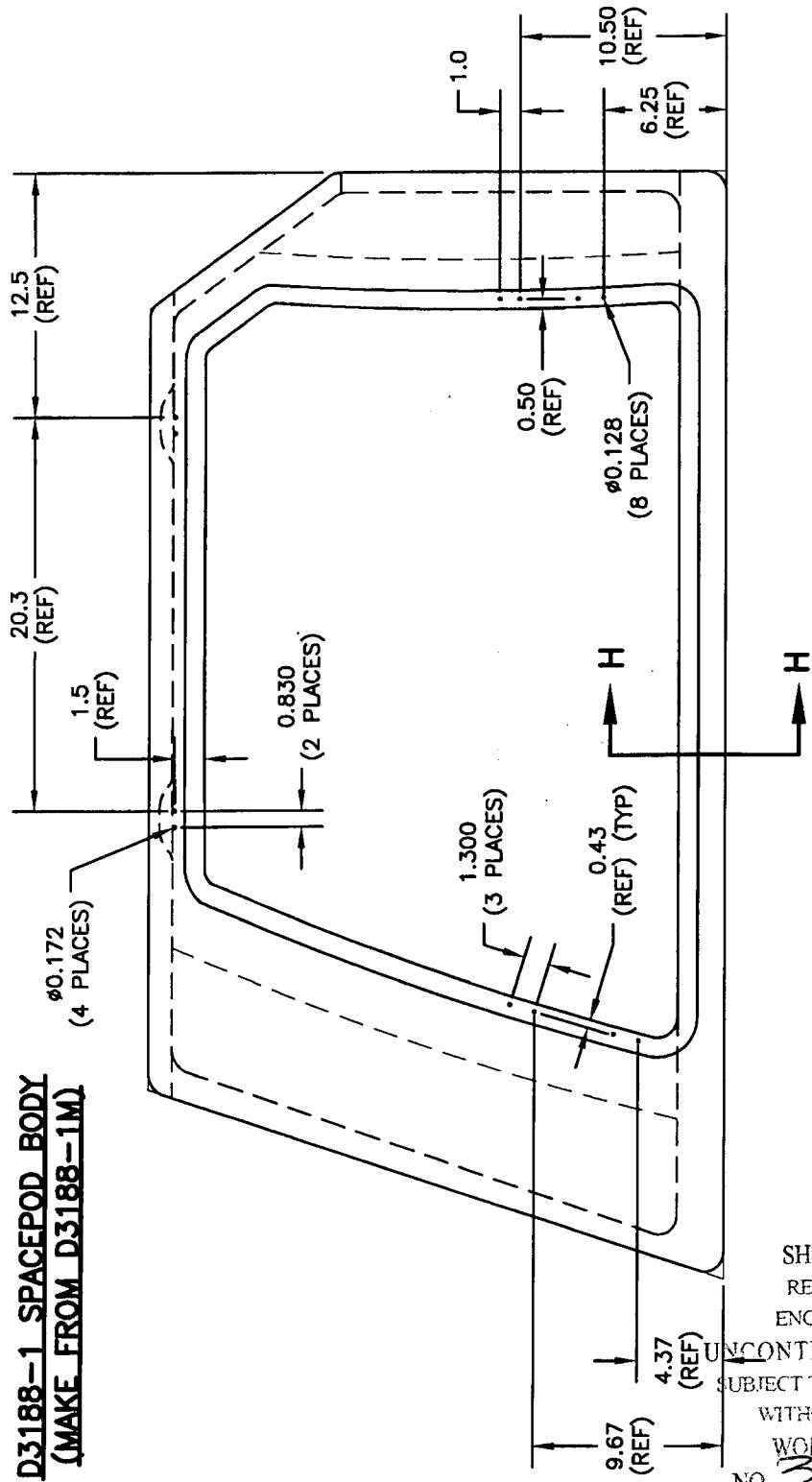
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07-02-22 *MM*

**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

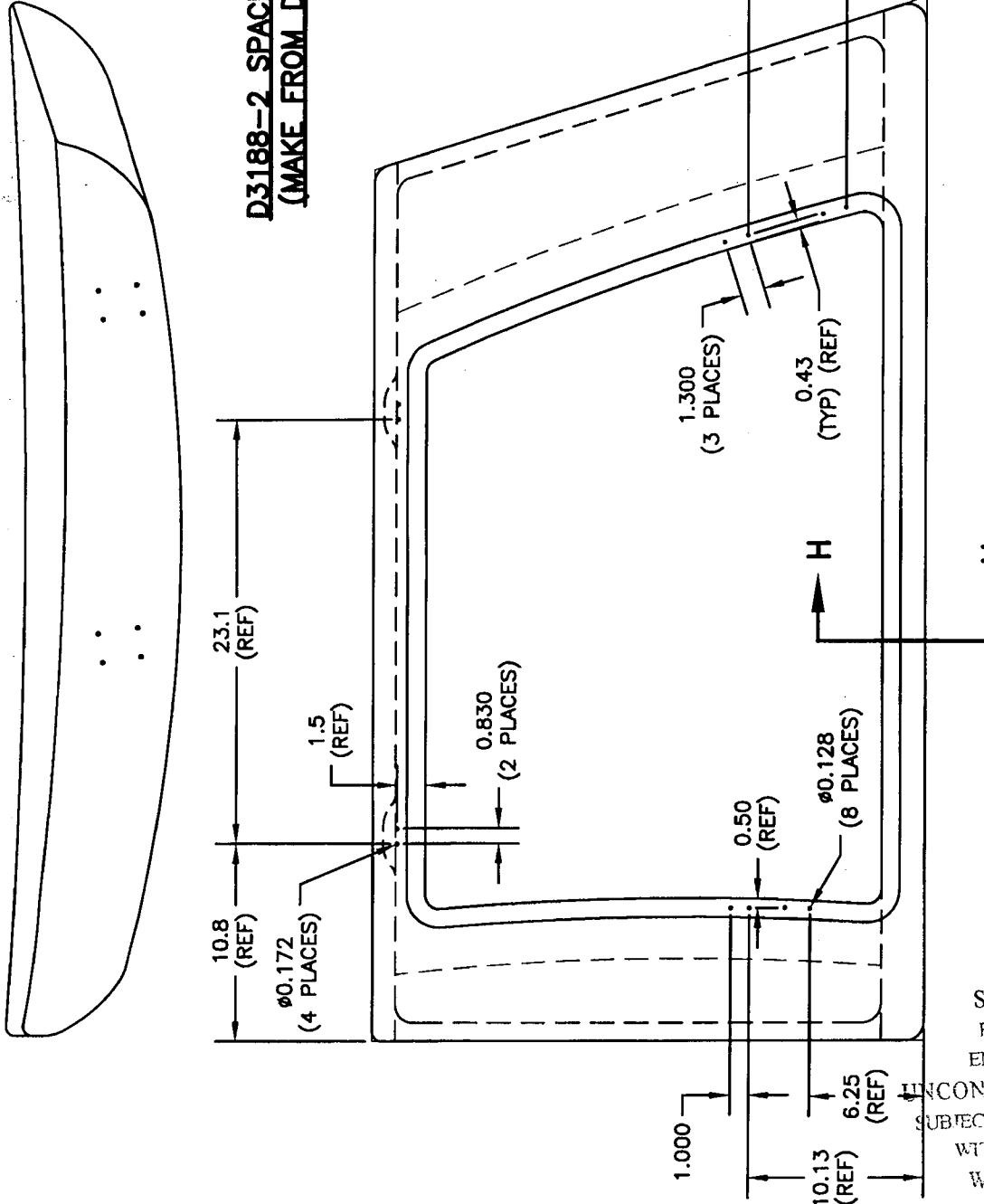


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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07.02.27 *AS***D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)****NOTES:**

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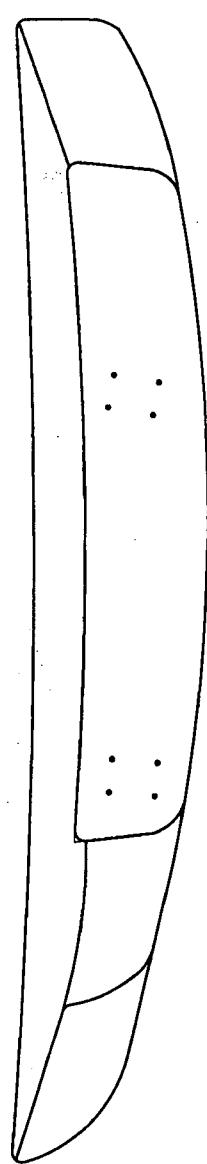
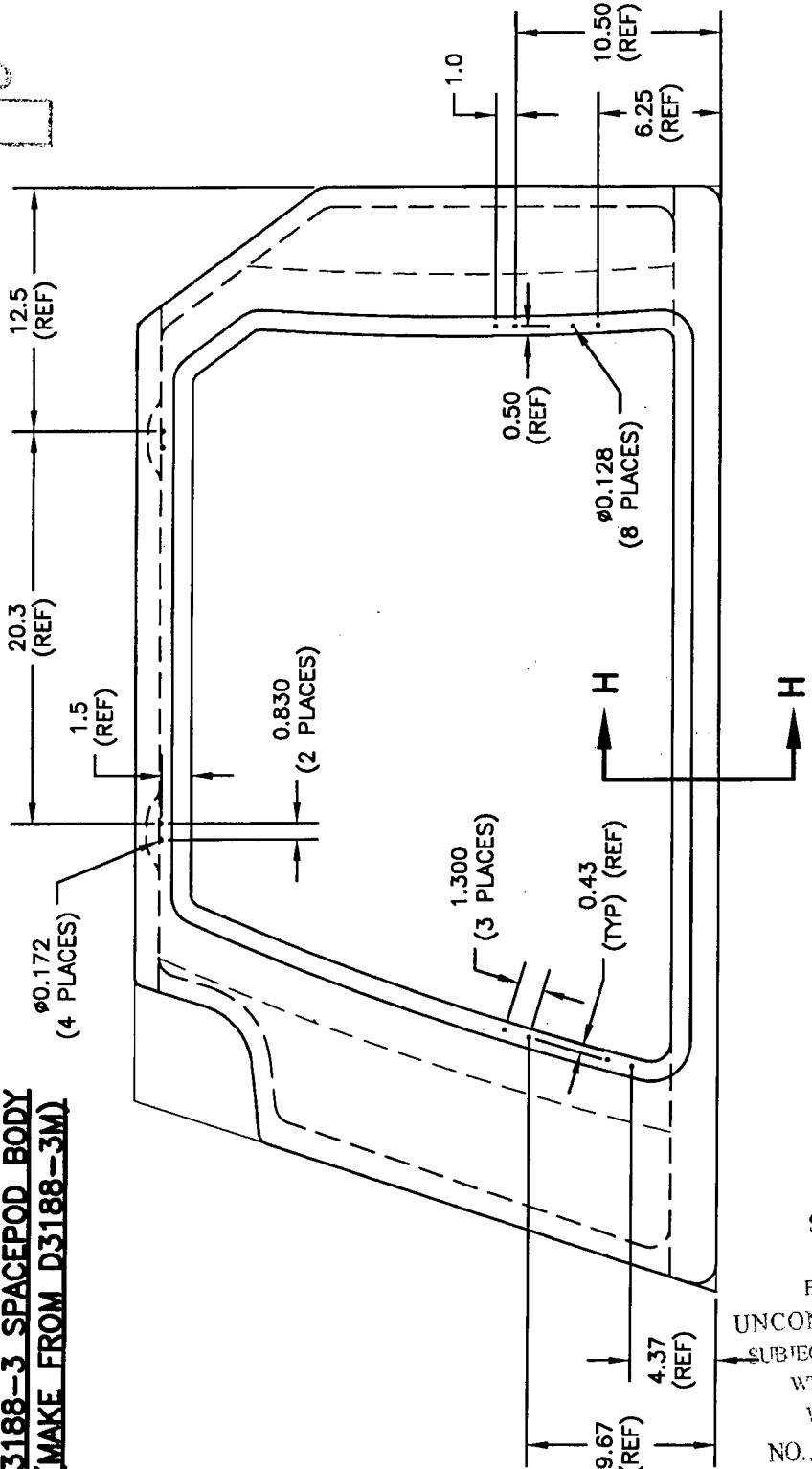
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07.02.27 *MM***D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

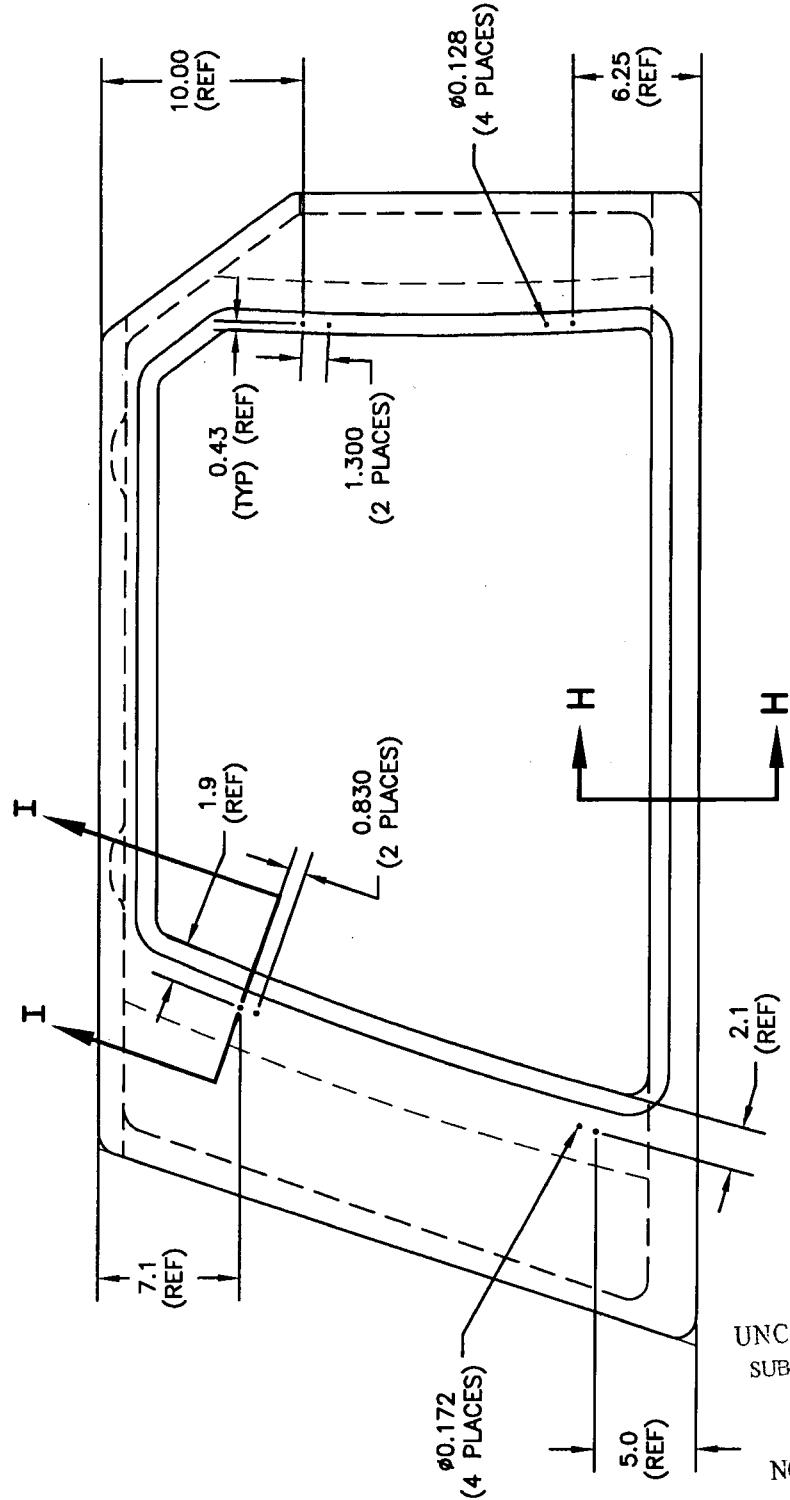
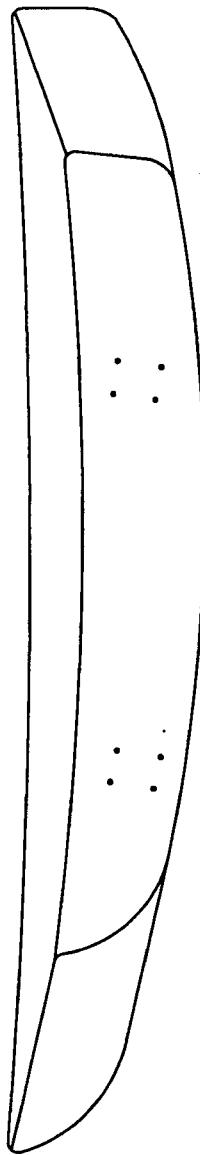
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.02.27 CE

**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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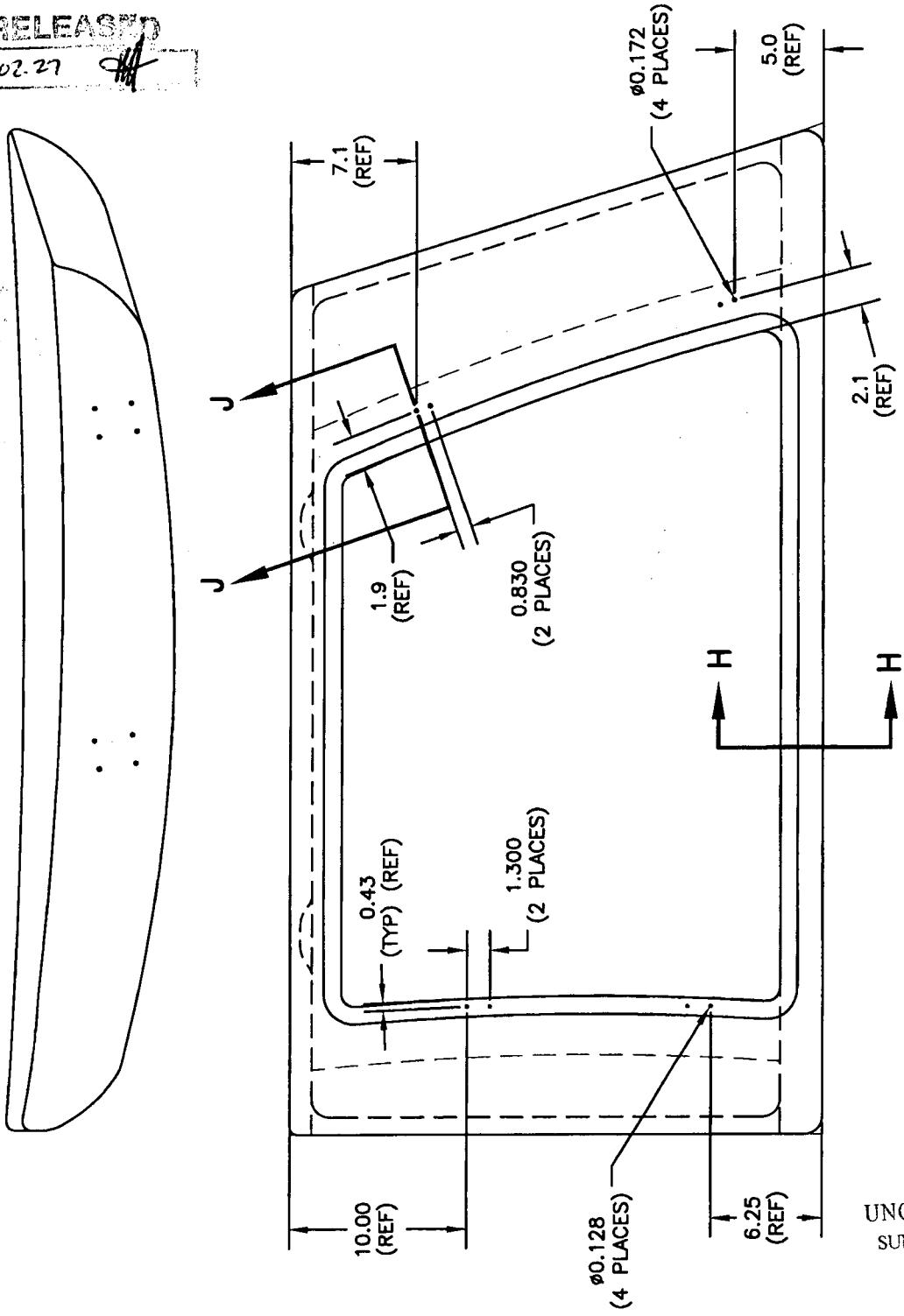
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07.02.27

**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)****NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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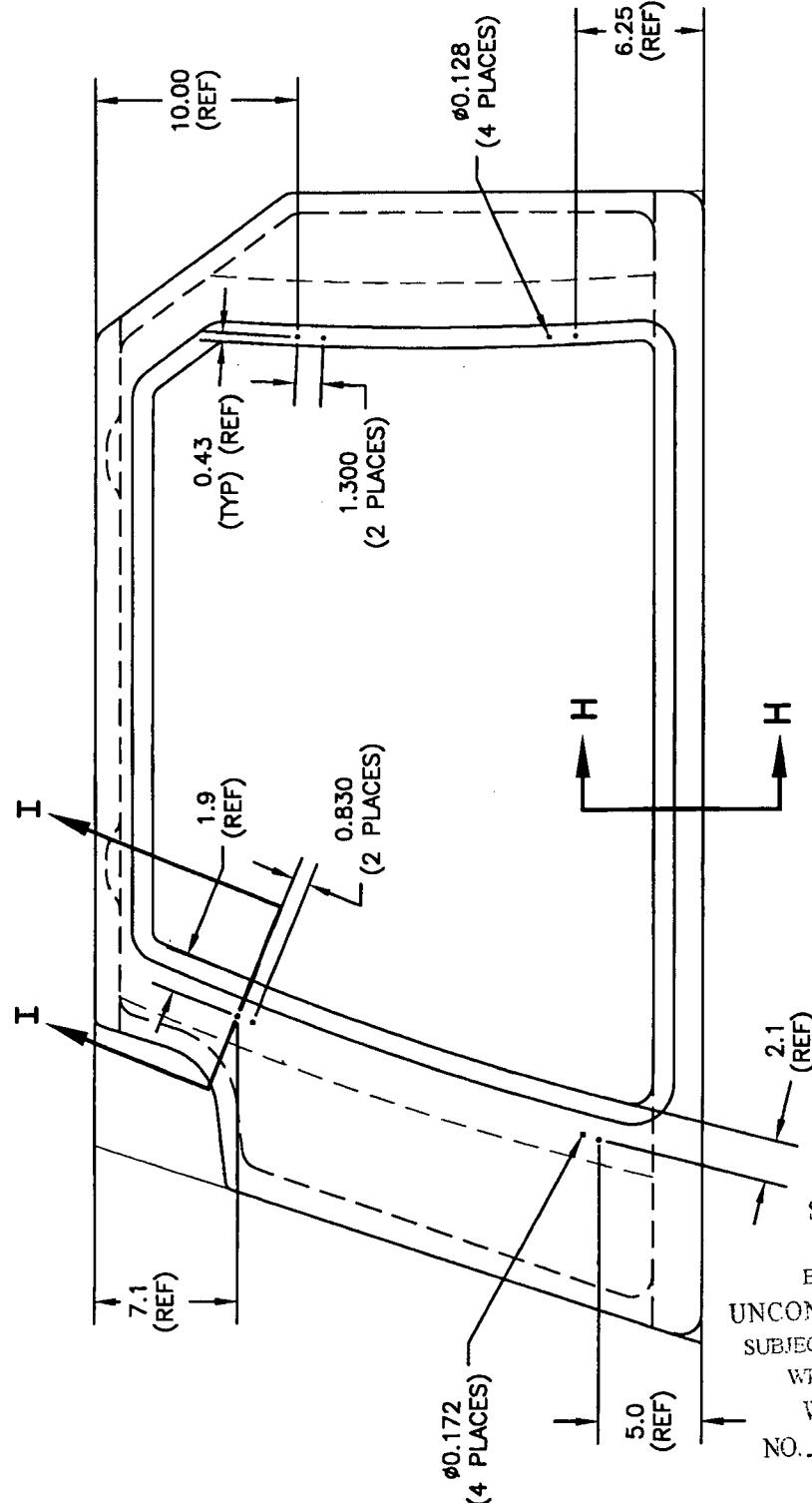
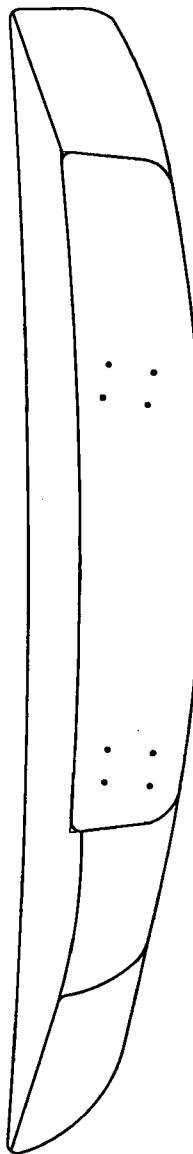
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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07.02.27

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)

NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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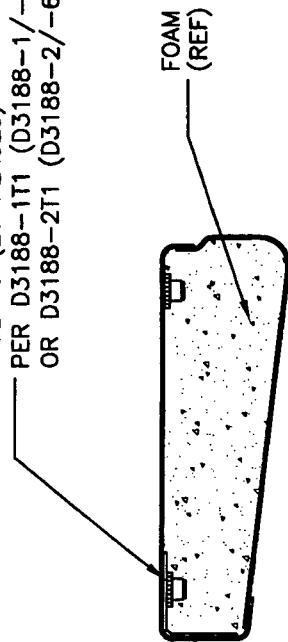
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

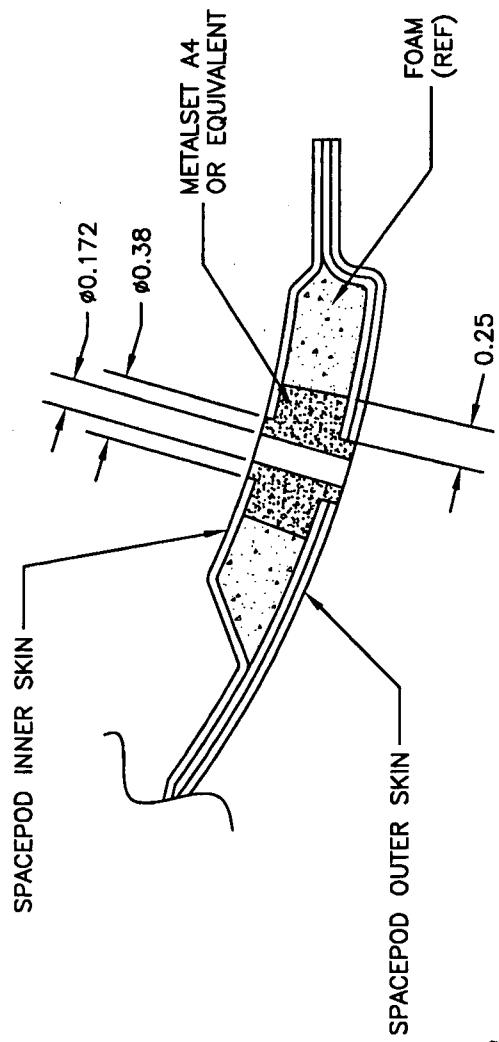
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07.02.22 *MM*

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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